

# Work Order ID 73523

Thursday, September 01, 2011 12:49:20 PM



Page 1

Item ID: D3969-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Spring (Basket Lid)

Start Date: 9/1/2011 Start Qty: 20.00



Cust Item ID:

Required Date: 9/9/2011 Req'd Qty: 20.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D3969

C

100

0.00



Purchasing

Memo

0.00

Issue P/O:

14805

Order as per Dwg D3969

Possible supplier: LS Technologies

part#: SSA4/6-122-315-310N

Material release note is required

CL 11/09/01 20

110

Receive & Inspect for Damage & Mat'l Certs

0.00



Packaging

Memo

0.00

Packaging

PL 11/17/11 (20)

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

# Work Order ID 73523

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Item ID: D3969-1

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Item Name: Spring (Basket Lid)

Start Date: 9/1/2011 Start Qty: 20.00



Cust Item ID:

Required Date: 9/9/2011 Req'd Qty: 20.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

120

QC6- Inspect dimensions to drawing

0.00



QC

Memo

0.00

Quality Control

8/10/10

counts  
820

130

Identify as per dwg & Stock Location: 85 272 0.00

0.00



Packaging

Memo

0.00

Packaging

20x

8/11-09-08

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/9/12

MF  
11-09-08

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

# Picklist Print

Thursday, September 01, 2011 12:49:18 PM

Work Order ID: 73523

Parent Item: D3969-1

Parent Item Name: Spring (Basket Lid)



Start Date: 9/1/2011

Required Date: 9/9/2011

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP RevA: New issue DD verified by:EC  
per revC DD 10.03.16 verified by:EC

IPP Rev:B as

| Component Item ID/<br>Item Name | Replacement<br>Item ID | Mfg/<br>Purch | Bin<br>Item | Primary<br>Location | Last<br>Location | Route<br>Seq ID | Unit of<br>Measure | Qty on<br>Hand | Qty per Kit | Total<br>Qty | Qty<br>Issued | Date<br>Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
| SSA4/6-122-315-310N             |                        | Purchased     | No          |                     |                  | 110             | Each               | 0.0000         | 1           | 20           |               |                |        |
|                                 |                        |               |             |                     |                  |                 |                    |                |             |              |               |                |        |

Gas Spring



9/1/11 (20)

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

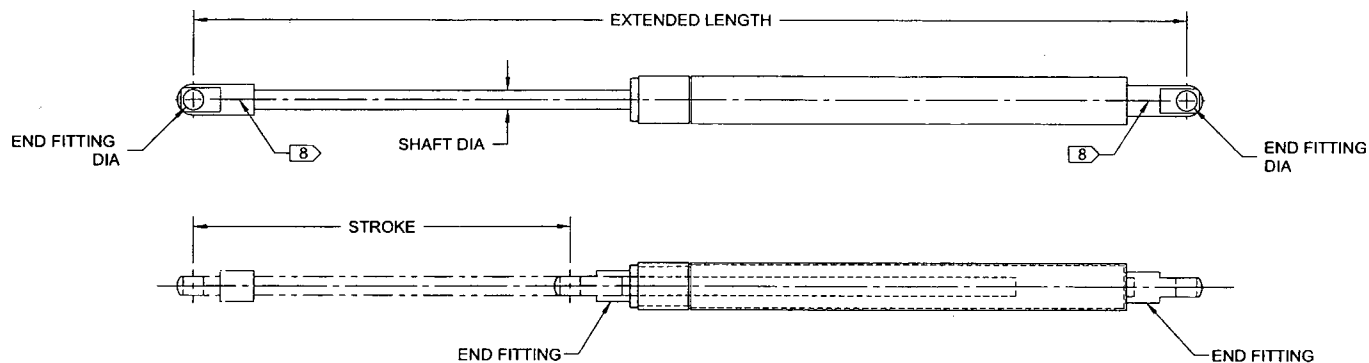
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

# SPECIFICATION CONTROL DRAWING



**D3969-X SPRING**

| DART PART NUMBER | STROKE (mm/in) | EXTENDED LENGTH (mm/in) | SHAFT DIA (mm/in) | FORCE (N/lbs) | END FITTING TYPE | END FITTING DIA (in) | CASING MATERIAL | PREFERRED SUPPLIER | SUPPLIER PART NUMBER | WEIGHT APPROX |
|------------------|----------------|-------------------------|-------------------|---------------|------------------|----------------------|-----------------|--------------------|----------------------|---------------|
| D3969-1          | 120/4.70       | 315/12.40               | 6/0.24            | 310/69.7      | BLADE            | 0.257                | STAINLESS STEEL | LS TECHNOLOGIES    | SSA4/6-122-315-310N  | 0.27 lbs      |
| D3969-3          | 120/4.70       | 315/12.40               | 8/0.31            | 360/80.9      | BLADE            | 0.257                | STAINLESS STEEL | LS TECHNOLOGIES    | SSA4/8-122-310-360N  | 0.32 lbs      |
| D3969-5          | 120/4.70       | 315/12.40               | 6/0.24            | 133/29.7      | BLADE            | 0.257                | STAINLESS STEEL | LS TECHNOLOGIES    | SSA4/6-122-315-133N  | 0.27 lbs      |

## NOTES:

- 1) MATERIAL: SEE CHART
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3969-X" AND B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: SEE CHART
- 8) CRIMP END FITTING AT APPROXIMATE LOCATION SHOWN, PER MANUFACTURERS REQUIREMENTS

**RELEASED**  
2010-03-12

|            |   |  |          |
|------------|---|--|----------|
| REV. C     | REDRAWN IN SW. ADDED -3 & -5; ADDED SHAFT DIA COLUMN TO CHART. FORCE FOR -1 CORRECTED (WAS 60.0 lbs). | JPH  | 10.03.04 |
| REV. B     | DRAWING RENAMED WAS: GAS SPRING (BASKET LID). NOTE 8 ADDED.   | AJS  | 09.11.10 |
| REV. A     | NEW ISSUE   | AJS  | 09.07.27 |
| REV.       | DESCRIPTION   | BY   | DATE     |
| DESIGN     | AJS   | <b>DART AEROSPACE LTD</b><br>HAWKESBURY, ONTARIO, CANADA<br>DRAWING NO. <b>D3969</b><br>TITLE <b>BASKET LID SPRING</b><br>SCALE NTS<br>REV. C SHEET 1 OF 1<br>COPYRIGHT © 2009 BY DART AEROSPACE LTD<br><small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small> |          |
| DRAWN      | AJS   |  |          |
| CHECKED    | [Signature]   |  |          |
| MFG. APPR. | N/A   |  |          |
| APPROVED   | [Signature]   |  |          |
| DE APPR.   | [Signature]   | DATE 10.03.04  |          |

*Handwritten:* 1073523

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
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| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries





Dart Aerospace Ltd.  
1270 Aberdeen Street  
Hawkesbury, ON K6A 1K7  
Tel: 613 632 9577  
Fax: 613 632 1053

\*\*\*PO REPRINT\*\*\*

Purchase Order ID **PO14805**

Purchase Order Date 9/1/2011

PO Print Date 9/1/2011

Page Number 1 of 2

Order From :

VC-LST0001

LS TECHNOLOGIES INC.  
303-103 STREET  
SASKATOON, SK S7N 1Y9  
CA

Contact Name

Vendor Phone 306 683 5000

Vendor Fax 306 683 6403

Vendor Account Nbr

Buyer

Chantal Lavoie

Requisition Nbr

Tax Resale Nbr 10127-2607

Terms

Net 30

Currency

CAD

FOB

Destination-Collect

Ship To :

DART AEROSPACE LTD

1270 ABERDEEN  
HAWKESBURY, ON K6A 1K7  
CANADA

FAKED  
(9/1/2011)

| Line Nbr | Reference<br>Revision ID<br>Vendor Part Number | Description/<br>Mfg ID     | Req Date/<br>Taxable              | Req. Qty/<br>Unit of Measure | Ship Method      | Unit Price | Extended<br>Price |
|----------|--|----------------------------|-----------------------------------|------------------------------|------------------|------------|-------------------|
| 1        | B8-220-530-070N                                | CARBON STEEL GAS<br>SPRING | 9/7/2011<br>Yes                   | 12.00<br>Each                | FedEx PI collect | \$36.8500  | \$442.20          |
|          |  | Special Inst:              | AS PER DWG D3552 REV. H<br>B73382 |                              |                  |            |                   |
| 2        | B6-220-530-140N                                | Door Prop                  | 9/7/2011<br>Yes                   | 16.00<br>Each                | FedEx PI collect | \$36.8500  | \$589.60          |
|          |  | Special Inst:              | AS PER DWG D3552 REV. H<br>B73497 |                              |                  |            |                   |
| 3        | BS104  | BALL STUD                  | 9/7/2011<br>Yes                   | 20.00<br>Each                | FedEx PI collect | \$1.1200   | \$22.40           |
|          |  | Special Inst:              | AS PER DWG D3554 REV. A<br>B73383 |                              |                  |            |                   |
| 4        | SSA4/6-122-315-310N                            | Gas Spring                 | 9/7/2011<br>Yes                   | 20.00<br>Each                | FedEx PI collect | \$65.0000  | \$1,300.00        |
|          |  | Special Inst:              | AS PER DWG D3969 REV. C<br>B73523 |                              |                  |            |                   |

9/1/2011

303 - 103 Street  
Saskatoon, SK Canada  
S7N 1Y9

| Date     | Invoice # |
|----------|-----------|
| 9/6/2011 | 7653      |

| Name / Address  |
|---|
| Dart Aerospace Ltd<br>1270 Aberdeen St.<br>Hawkesbury, ON K6A 1K7 |

|   |
|---|
| Ship To   |
| Main Finished Goods Location<br>Dart Aerospace Ltd<br>1270 Aberdeen St.<br>Hawkesbury, ON K6A 1K7 |

|          |          |        |     |         |
|----------|----------|--------|-----|---------|
| P.O. No. | Ship     | Via    | FOB | Project |
| PO14805  | 9/2/2011 | Fed-Ex |     |         |

| Qty | Description  |
|-----|--|
| 12  | B8-220-530-070N Gas Spring ( D3552 Rev H)                    |
| 16  | B6-220-530-140N Gas Spring ( D3552 Rev H )                   |
| 20  | BS104 - 10mm Ball Stud Zinc 5/16-18 Thd .75" Lg with Locknut |
| 20  | SSA4/6-122-315-310N Stainless Gas Spring ( D3969 Rev C)      |
| 30  | SSA4/8-122-310-360N Stainless Gas Spring ( D3969 Rev C)      |
|     | Shipping Via FED EX Tracking #795153667815                   |



303 - 103<sup>rd</sup> Street, Saskatoon, Saskatchewan, Canada S7N 1Y9  
Ph: (306) 683-5000 Fax: (306) 683-6403

### Certificate of Compliance

This is to certify that the parts listed below meets specifications as required by your order.

12 Units: B8-220-530-070N Gas Spring ( D3552 Rev H)

16 Units: B6-220-530-140N Gas Spring ( D3552 Rev H )

20 Units: BS104 - 10mm Ball Stud Zinc 5/16-18 Thd .75" Lg with Locknut

20 Units: SSA4/6-122-315-310N Stainless Gas Spring ( D3969 Rev C)

30 Units: SSA4/8-122-310-360N Stainless Gas Spring ( D3969 Rev C)

*Sutorlor*

Country of Manufacture: Canada

Date of Manufacture : September 2011

This product is ROHS compliant.

We certify no mercury was used in the manufacture of this order.

Purchase Order # 14805

Invoice # 76553

L S Technologies Inc Canada

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Mark Ingram  
Manager